

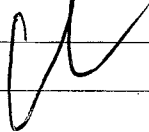
Work Order ID 148099

Friday, June 24, 2016 10:38:20 AM

148099

Page 1

Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft, In
 Start Date: 6/15/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/27/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2574	F								

100

0.02

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 148099

Double check by: gmk

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

DAS

44

9-89

16-06-29

DAS

14

9-89

16/06/30

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2573 & D2574

DAS
08
9-89

16/07/07

DAS

44

9-89

16-07-05

DAS

14

9-89

16/07/06

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Friday, June 24, 2016 10:38:20 AM

Item ID: D2574

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, Aft, In

Stop ***NS2***

Start Date: 6/15/2016 Start Qty: 4.00

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Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.01	DA 0E 9-E	B.2	16/07/07				DAS 14 2-30 16/06/30
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				4			SL 16-7-7
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.02				(4)			2d6/0741 BEB

Work Order ID 148099***148099***

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Item ID: D2574

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft, In

Start Date: 6/15/2016 Start Qty: 4.00

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Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.07

Quality Control

DAS
21
9-89 JUL 14 2016

DAS
21
9-89 JUL 14 2016

Picklist Print

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Page 1

Work Order ID: 148099

148099

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft, In

Start Date: 6/15/2016

Required Date: 6/27/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 *D6101-005* Saddle Billet		Manufactured	No			110	Each	20.0000	1	4			
											DAS 44 9-89	16-06-28	

Location

Loc Qty

Loc Code

MAT040

20

146278

20

4

DART AEROSPACE LTD	Work Order: 148099
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262		0.260	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.125	0.127	0.125	0.126		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.129	0.127	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.227	3.227	3.227		
V	0.230	0.250		0.237	0.240	0.242	0.242		
W	0.115	0.135		0.130	0.125	0.125	0.125		
X	0.307	0.312		0.312	0.312	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.624	0.624	0.624		
AC	0.053	0.073		0.060	0.060	0.060	0.060		
AD	0.240	0.260		0.250	0.250	0.252	0.252		
AE	1.500	1.520		1.511	1.511	1.511	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.275	0.275	0.275	0.275		
AH	0.240	0.260		0.247	0.246	0.247	0.247		
AI	2.000	2.020		2.0015	2.001	2.001	2.000		
AJ	0.023	0.043							
Accept/Reject									

Measured by: <u>gml</u> / <u>H. a</u>	DAS
Date: <u>11/10/13</u> / <u>16/07/07</u>	08

Audited by: <u>JK</u>
Date: <u>16-7-7</u>

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

